

SHIP ALONE TO OFFSHORE DO NOT assemble

Work Order ID 112712

112712

Page 1

Wednesday, February 05, 2014 2:58:55 PM

Item ID: D3391-025 Accept: *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Tube Assembly
Start Date: 2/5/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 2/14/2014 Req'd Qty: 1.00 *1* Customer:
Reference:..

Approvals: Process Plan: Date: 14-02-6 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100 0.00

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: 4

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

112

112

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

1 ϕ Ki
mm-L
14/02/14

1 ϕ Ki
mm-L
14/02/24

1

SPC
14/02/27

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Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: E
2-Deburr*on 14/03/16*1 0

130

0.00

130

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

*on 14/03/16*1 0

140

0.00

140

QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

INSPECT INSIDE BORE

*B.o 14/03/18*1 0DAS
08
9-89

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Tube Assembly

Stop ***NS2***

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DC 14/03/19

160

160

CNC Bend 1

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DC 14/03/25

170

170

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

DAS
03
9-89

14-3-25

H-4.28"

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.297" and c'bore as per dwg D3391								
	6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.								
	7-Deburr								
	8- Scribe batch # on fwd end								

DC 14/03/31

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Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

210

QC7-Inspect Chemical Conversion Coat

0.00

210

QC

Memo

0.00

Quality Control

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Item ID: D3391-025 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 2/5/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/14/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220									
Skidtubes	Memo	0.00							
Skidtubes	1- Instal spacers as per dwg D3391 A/R Magnabond 6398/ Batch: <u>127227</u> exp. date: <u>14/05/05</u> cure time 12hrs as per QSI0015								
	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89
① 14-04-02

112712

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/5/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/14/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

235

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

240

Memo

0.00

Powdercoat

Powder Coating

START TIME

OVEN TEMP

OVEN TEMPERATURE: 350
FINISH TIME: 2.15

FINISH TIME

QC3- Inspect Part Finish

0.00

250

Memo

0.00

QC

Quality Control

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Item ID: D3391-025 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 2/5/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/14/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260		0.00							
260	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 <u>N/A 128569</u> Sikaflex expiry date: <u>10/10</u> 3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: <u>N/A</u>	0.00							
280									
Packaging	Memo	0.00							
Packaging									

1x of all w/lot 1x

SNP
MMS

1x of all w/lot 1x

1x & 14-04-23

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Tube Assembly

Stop ***NS2***

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

QC21- Final Inspection - Work Order Release

0.00

290

QC

Memo

0.00

Quality Control

R 114428

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
--	--	--	--

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
--	--	---

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

100-100000

100-100000

Picklist Print

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Work Order ID: 112712

112712

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	18.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4095-047

Wearpad Assembly

HL 14/04/14

Location

Loc Qty

Loc Code

FP001

18

102241

2

108289

16

D4095-049

Manufactured No

260 Each

13.0000

1

1

D4095-049

Wearpad Assembly

HL 14/04/14

Location

Loc Qty

Loc Code

FP001

12

109670

12

FP002

1

102216

1

D6014-090

Manufactured No

100 Each

77.0000

1

1

D6014-090

ALUMINUM EXTRUSION

Location

Loc Qty

Loc Code

LG003

77

79742

17

86063

60

mm.L 14/02/18

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Work Order ID: 112712

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

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D3391-025

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230 Each

351.0000 4 4

D3670-4-200

Bushing

**

02/14/03/31

Location

Loc Qty

Loc Code

FG

10

87709

10

LG001

341

103880

60

109108

242

96240

39

Manufactured No

270 Each

23.0000 1 1

D2646

D2646

Aft Cap

**

14/04/14

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

19

103306

18

107857

1

Manufactured No

270 Each

850.0000 2 2

D3672-1

D3672-1

Phenolic Washer

**

14/04/14

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

840

103845

100

93886

522

99099

218

VZ

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Work Order ID: 112712

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

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D3391-025

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 AELS4-1032-130 Purchased

No

260

Each

57.0000

14

14

AI S4-1032-130

Rivnut

**

all 14/02/14

Location

Loc Qty

Loc Code

st510

57

M126109

57

M128649

x14

ALS4-1032-225 AELS8-1032-225 Purchased

No

270

Each

101.0000

8

8

AI S4-1032-225

Rivnut

**

all 14/02/14

Location

Loc Qty

Loc Code

FG

30

M127028

30

M128179

x8

ST280

10

M127028

10

st555

61

M127092

61

AN3C4A

Purchased

No

270

Each

2,616.000

6

6

AN3C4A

Bolt

**

all 14/02/14

Location

Loc Qty

Loc Code

FG

20

122814

20

M128739

x6

ST513

2596

125388

1835

M127410

261

M127832

500

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Work Order ID: 112712

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 270 Each 1,881.000 4 4

AN3C5A

Bolt

**

ll m10d16

Location

Loc Qty

Loc Code

FG 5

122800 5

ST350 1876

M128057 1876

NAS1149C0332R Purchased No 270 Each 9,652.000 10 10

NAS1149C0332R

WASHER

**

ll m10d16

Location

Loc Qty

Loc Code

GA 1169

125654 1169

st510 8483

m126319 865

m127306 2500

m127410 3000

m127831 2118

M120591

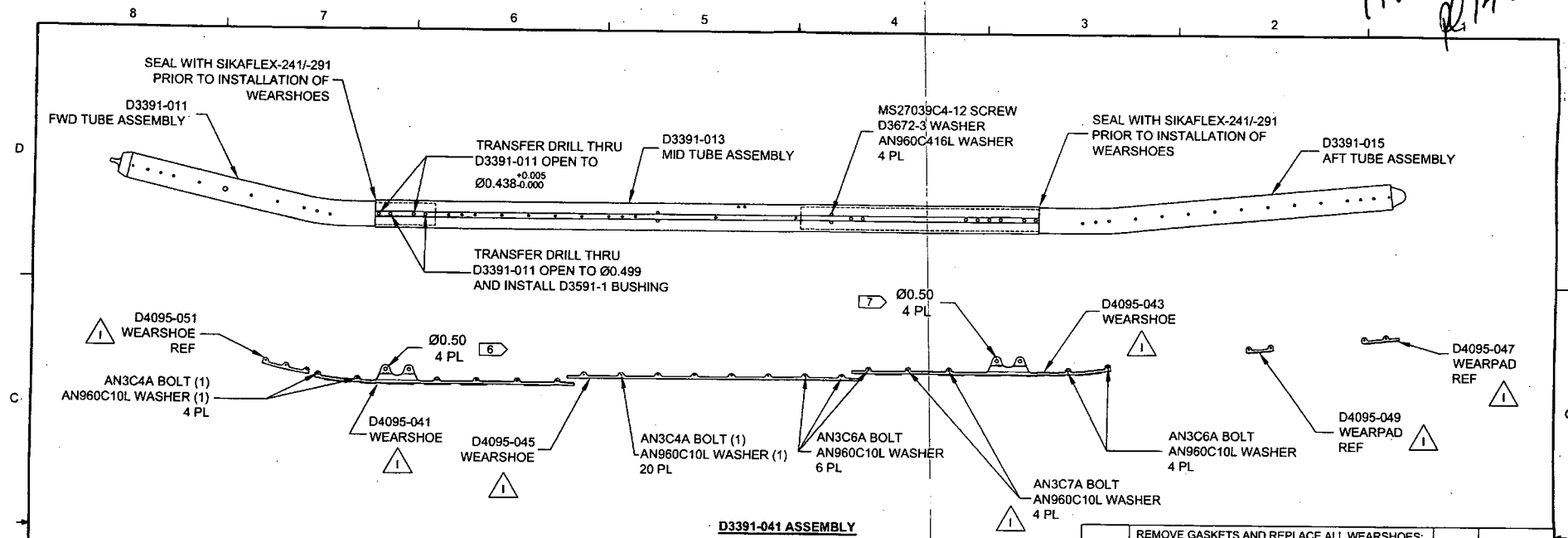
x10

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14-026



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

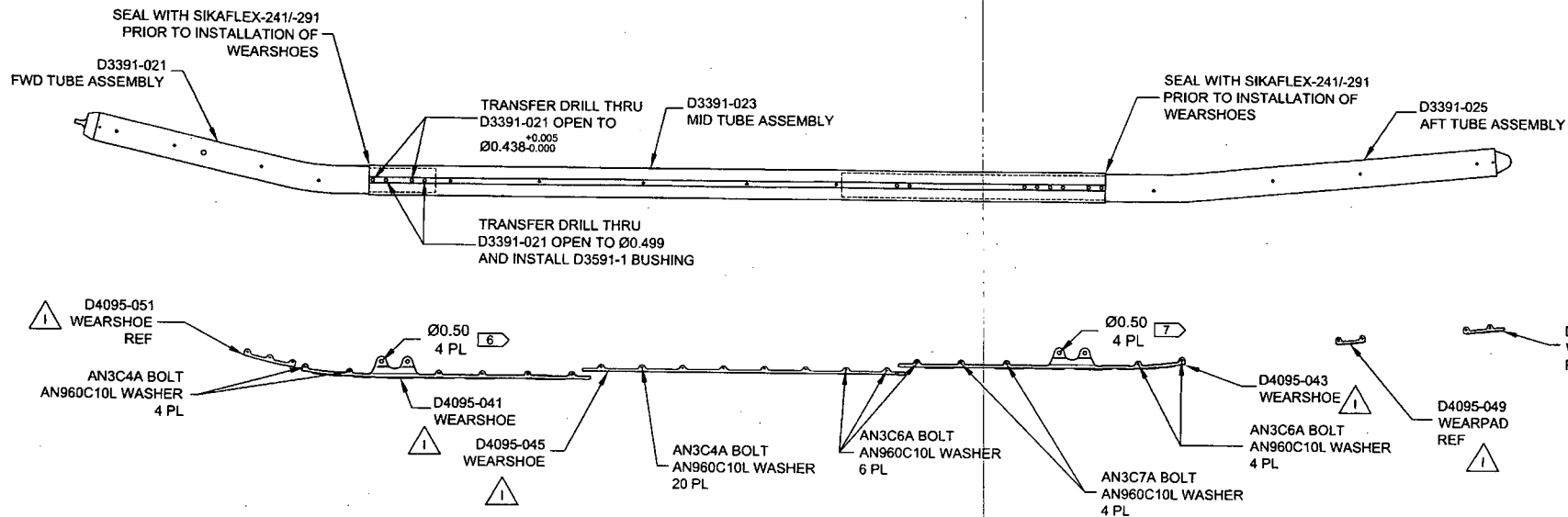
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1). FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2). COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3). TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4). UNITS: INCHES UNLESS OTHERWISE NOTED
- 5). USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6). FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7). FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN#11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

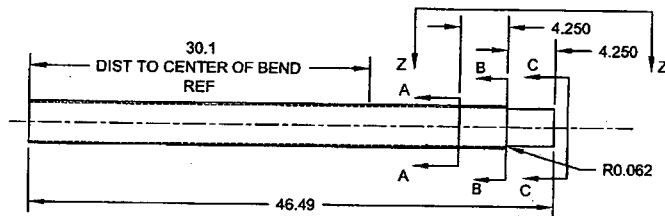
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

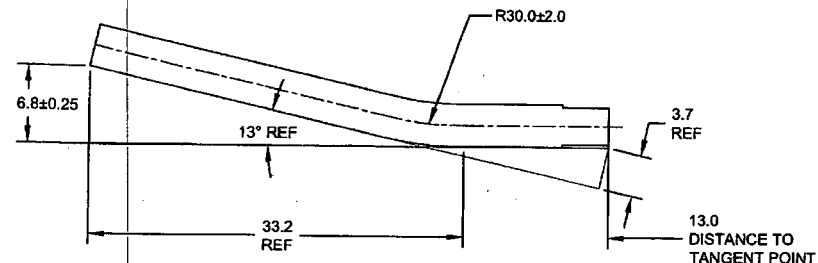
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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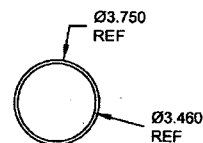
DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
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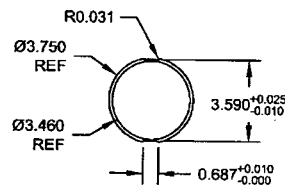
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



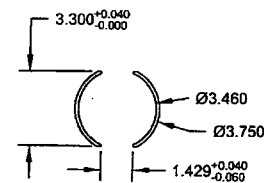
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



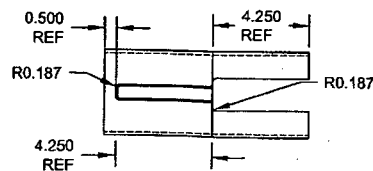
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



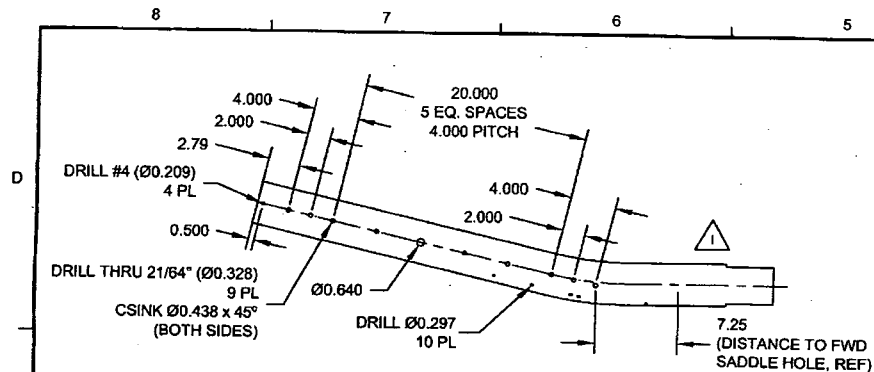
SECTION C-C
SCALE 2X



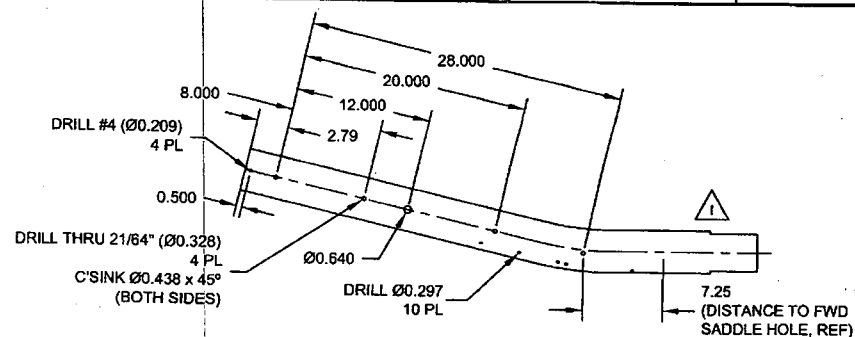
VIEW Z-Z
SCALE 2X

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2011-11-04

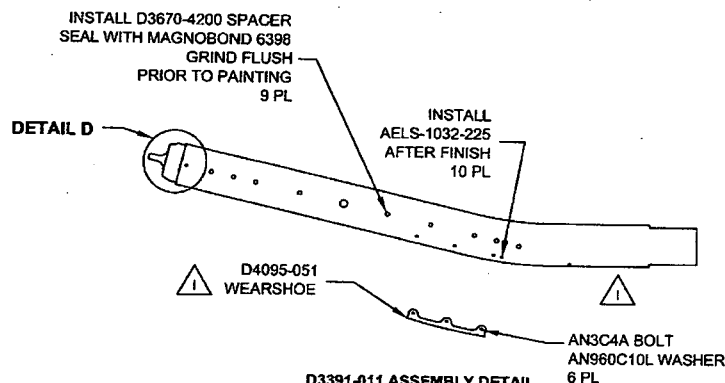
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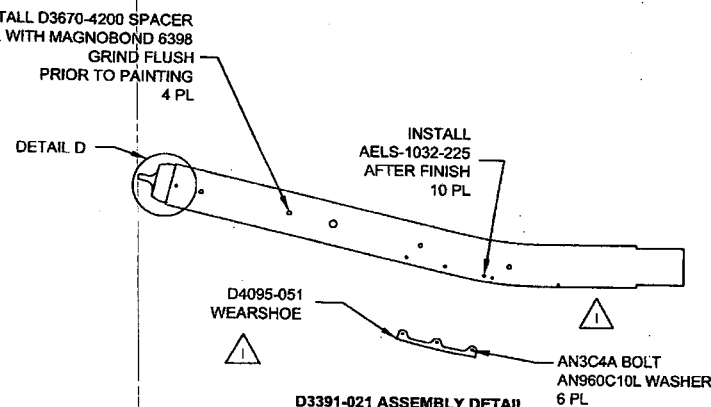
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

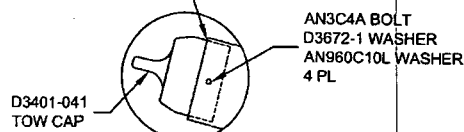


D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

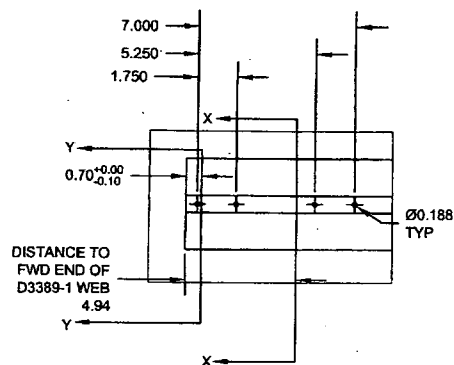
SEAL WITH
SIKAFLEX-241/-291



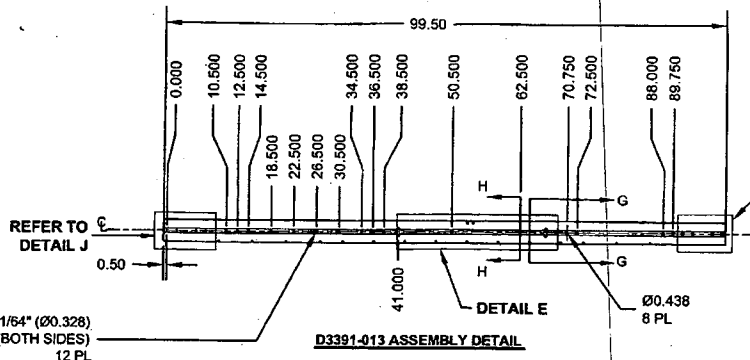
DETAIL D
SCALE 2X

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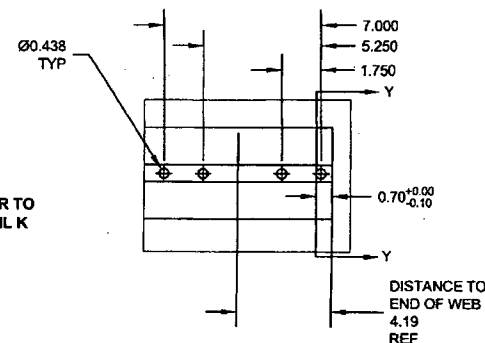
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DETAIL J
SCALE 4X



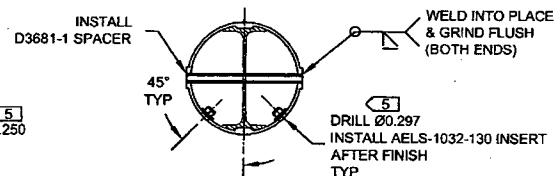
D3391-013 ASSEMBLY DETAIL
SCALE 5X



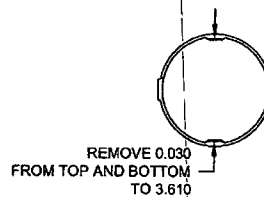
DETAIL K
SCALE 4X



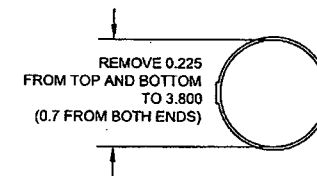
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



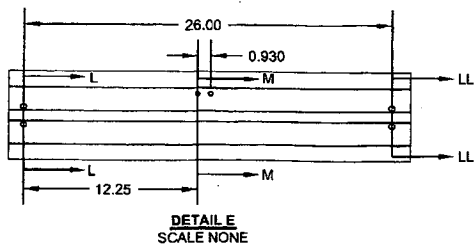
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

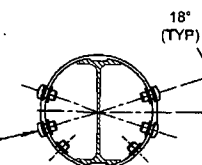
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

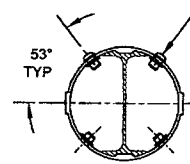
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004



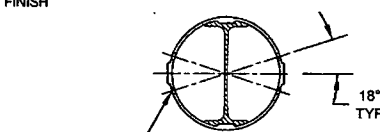
DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X



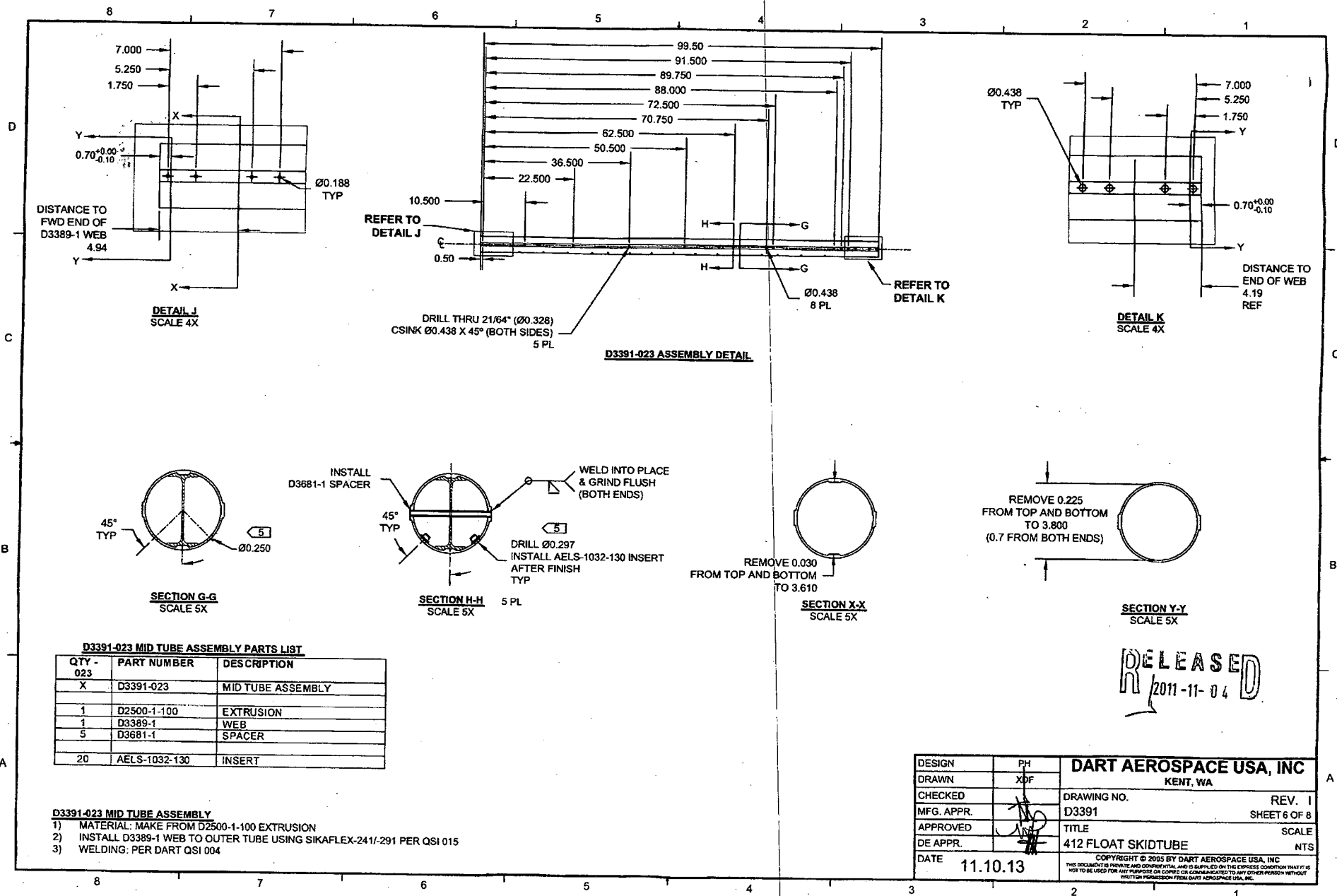
SECTION M-M
SCALE 5X

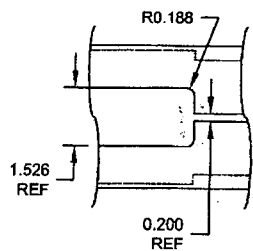


SECTION LL-LL
SCALE 5X

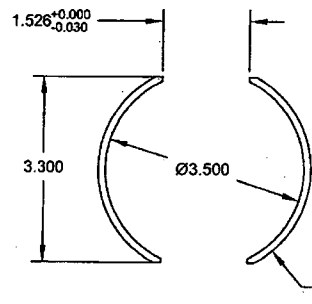
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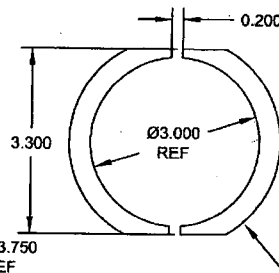




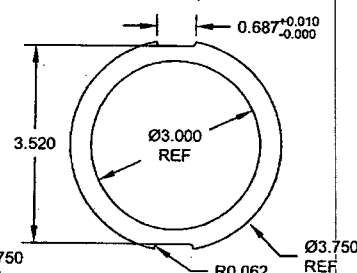
VIEW BB-BB
SCALE 4X



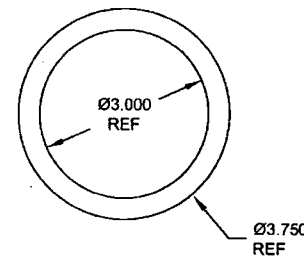
SECTION AA-AA
SCALE 6X



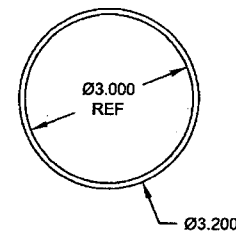
SECTION N-N
SCALE 6X



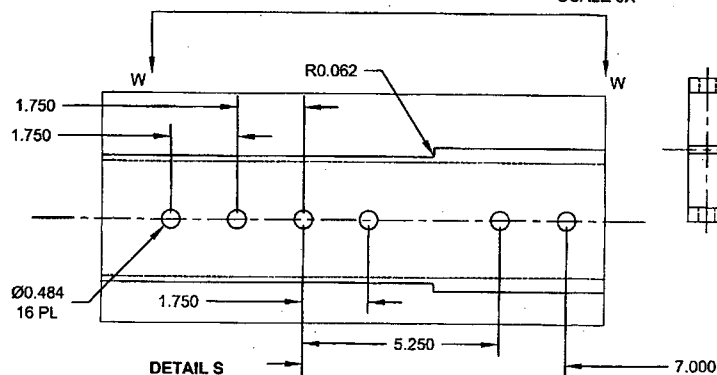
SECTION P-P
SCALE 6X



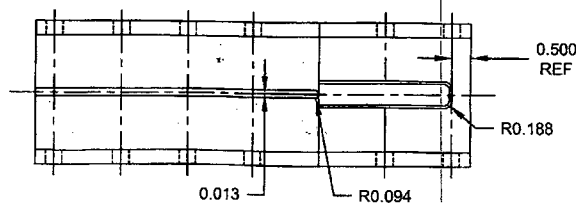
SECTION Q-Q
SCALE 6X



SECTION R-R
SCALE 6X



DETAIL S
SCALE 4X



VIEW W-W
SCALE 4X

D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

DETAIL S

36.435
TO TAPER

MACHINE CONSTANT
TAPER FROM Ø3.750
TO Ø3.200

DETAIL V

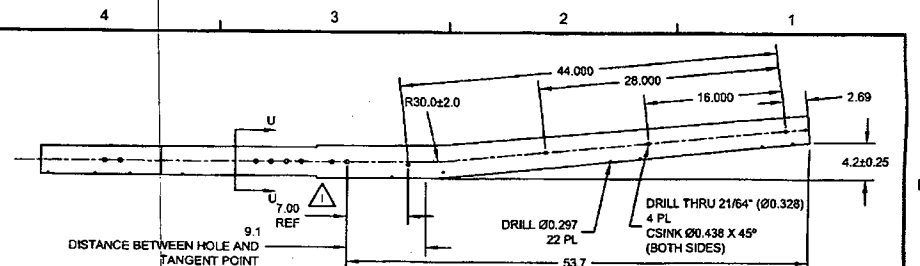
CHAMFER
30°X0.060 DEEP

DRILL #4 (Ø0.209)
2 PL

DETAIL V
SCALE 6X

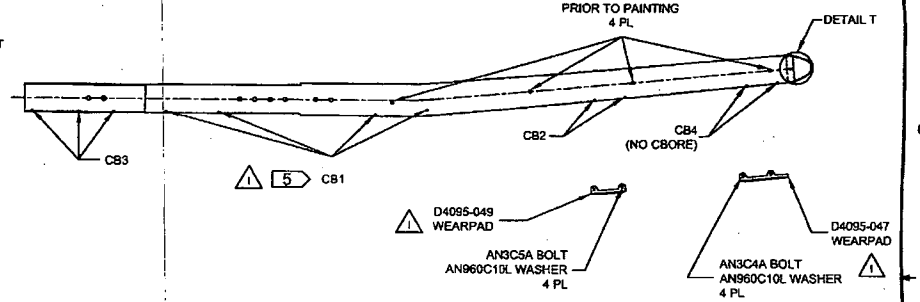
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2011-11-04

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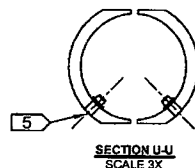
D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING

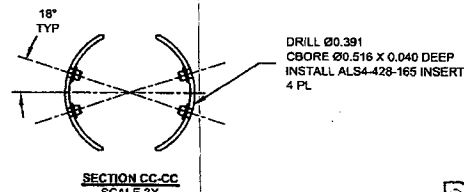


D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

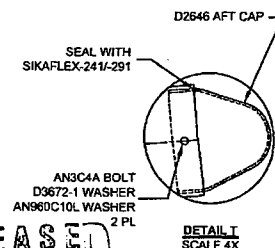
QTY - 016	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-429-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN860C10L	WASHER



SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 2X





DETAIL 1
SCALE 4"

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBØRE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBØRE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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DART AEROSPACE LTD		Work Order: 112712
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		TAPE	LG-25
3.500	+/-0.010	3.503	✓		VERN	CNC 08
Ø3.200	+/-0.010	3.202	✓		VERN	
Ø3.750	+/-0.010	3.750	✓		VERN	
30° x 0.060 chamfer	+/-0.010	30° x 0.060	✓		VERN	↓
88.93	+/-0.030	88.96	✓		TAPE	LG-25

Measured by: ZNAN.L/KC	Date: 14/02/19
Audited by: Smb	Date: 14/2/19

HAAS Section						
1.526	+0.000/-0.030	1.505	✓		Vern	ML-06
7.500	+/-0.010	7.500	✓		"	
27.750	+/-0.010	27.750	✓		TAPE	ML-08
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.298	✓		Vern	ML-06
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.524	✓			
0.687	+0.010/-0.000	.687	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.484	+0.005/-0.001	Ø.487	✓			

Measured by: KEC Smb	Date: 14/02/19/03/16
Audited by: D.A.	Date: 14/03/18

Date	Change	Revised by	Approved
06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
06.06.19	Dwg revision update	KJ/JLM	
07.04.20	Ø0.208 dimension removed	KJ/JLM	
07.09.06	0.400 dimension removed	KJ/JLM	
07.11.23	Dwg Rev. updated	KJ/EC/DD	
04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
11.16	Dimension 0.200 removed	KJ	
06.21	Dimension 44.995 removed	KJ	
05.15	Dwg Rev updated	KJ	
05.23	Dimension updated	KJ	
0.15	88.93 dimension removed	KJ	
0.28	88.93 dimension added	KJ	

